

MILITARY SPECIFICATION

COAT, WOMAN'S, (PANT SUIT)

This specification is approved for use within the Department of the Air Force, and is available for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification covers the requirement for a woman's, polyester/wool, tropical coat.

1.2 Classification. The coat shall be of one type furnished in the following classes, as specified (see 6.2):

Class 1 - Polyester/Wool, USAF Blue 1578, 10.00 oz.
Class 2 - Polyester/Wool, USAF Blue 1608, 10.25 oz.

1.2.1 Lengths and sizes. The coat shall be furnished in the following lengths and sizes, as specified (see 6.2):

<u>Schedule of lengths and sizes</u>								
Short	6	8	10	12	14	16		
Regular	6	8	10	12	14	16	18	20
Long	6	8	10	12	14	16	18	

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: ASD/ENES, Wright-Patterson AFB OH 45433-6503 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter

AMSC N/A

FSC 8410

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2. APPLICABLE DOCUMENTS

2.1 Government documents

2.1.1 Specifications and standards. The following specifications and standards form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of these documents shall be those listed in the issue of the Department of Defense Index of Specifications and Standards (DoDISS) and supplement thereto, cited in the solicitation.

SPECIFICATIONS

FEDERAL

A-A-50067	Cloth, Flannel, Wool
V-T-276	Thread, Cotton
V-T-280	Thread, Gimp, Cotton, Buttonhole
V-T-285	Thread, Polyester
V-T-295	Thread, Nylon
V-T-301	Thread, Silk
NN-P-71	Pallets, Material Handling, Wood, Stringer Construction, 2-Way and 4-Way (Partial)
CCC-C-438	Cloth, Buckram, Woven and Nonwoven
DDD-L-20	Label: For Clothing, Equipage, and Tentage, (General Use)
DDD-T-86	Tape, Textile; Cotton, General Purpose (Unbleached, Bleached, or Dyed)
PPP-B-636	Boxes, Shipping, Fiberboard

MILITARY

MIL-C-297	Cloth, Interlining, Cotton Warp, and Spun Hair-Wool or Rayon Filling
MIL-C-368	Cloth, Satin, Rayon and Cloth, Twill, Rayon
MIL-B-3461	Button, Insignia, Metal, Uniform and Cap
MIL-P-15011	Pallets, Material Handling, Wood Post Construction, 4-Way Entry
MIL-P-15064	Pads, Shoulder and Sleeve-Head
MIL-C-16375	Cloth, Wigan, Cotton
MIL-C-21115	Cloth, Tropical: Wool, Polyester/Wool
MIL-C-43718	Cloth, Polyester; Polyester and Cotton; Polyester and Rayon, For Pockets
MIL-C-44192	Container, Shipping and Storage, Coat (Hanger Pack)

STANDARDS

FEDERAL

FED-STD-191	Textile Test Methods
FED-STD-751	Stitches, Seams, and Stitchings

MIL-C-87160A(USAF)

MILITARY

MIL-STD-105	Sampling Procedures and Tables for Inspection by Attributes
MIL-STD-129	Marking for Shipment and Storage
MIL-STD-147	Palletized Unit Loads
MIL-STD-1608	Provisions for Evaluating Quality of Coats, Women's Dress
MIL-STD-2073-1	DoD Materiel Procedures for Development and Application of Packaging Requirements

2.1.2 Other Government documents. The following other Government document forms a part of this specification to the extent specified herein. Unless otherwise specified, the issues shall be those in effect on the date of the solicitation.

LAWS AND REGULATIONS

Rules and Regulations Under the Wool Products Labeling Act of 1939

(Application for copies should be addressed to the Superintendent of Documents, Government Printing Office, Washington DC 20402-0001.)

(Copies of specifications, standards, and other Government documents required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting activity.)

2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of the documents which are DoD adopted shall be those listed in the issue of the DoDISS specified in the solicitation. Unless otherwise specified, the issues of documents not listed in the DoDISS shall be the issue of the nongovernment documents which is current on the date of the solicitation.

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM D 3951 Standard Practice for Commercial Packaging

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race St., Philadelphia PA 19103-1187.)

THE COLOR ASSOCIATION OF THE UNITED STATES

Department of Defense (DoD) Standard Color Card of Official Standardized Shades for Sewing Threads

(Application for copies should be addressed to The Color Association of the United States, 343 Lexington Ave., New York NY 10016-0927.)

(Nongovernment standards and other publications are normally available from the organization which prepare or which distribute the documents. These documents also may be available in or through libraries or other informational services.)

2.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein, the text of this specification shall take precedence. Nothing in this specification, however, shall supersede applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 Standard samples. Standard samples, when furnished (see 6.3), are solely for guidance and information to the contractor. Variations from the document may appear in the samples, in which case the document shall govern.

3.2 First article. When specified in the contract or purchase order, a sample shall be subjected to first article inspection (see 4.4 and 6.2).

3.3 Materials (see 6.5)

3.3.1 Basic material. The basic material for the class 1 coat shall be USAF Color Blue, Shade No. 1578 conforming to type III, class 3 of MIL-C-21115. Material for the class 2 coat shall be USAF Color Blue, Shade No. 1608 conforming to type III, class 4 of MIL-C-21115.

3.3.2 Rayon cloth. The material for the body lining and the sleeve lining shall conform to class 1 of MIL-C-368 and shall be USAF Color Blue, Shade No. 1086 (see 6.3).

3.3.3 Cotton-warp, hair-wool-filling cloth. The material for the front interlining and the shoulder loop interlining shall conform to type III, class 2 of MIL-C-297.

3.3.4 Sleeve-head pads. The sleeve-head pads shall conform to type IV of MIL-P-15064.

3.3.5 Polyester and cotton twill cloth. The material for the patch pocket lining, the pocket stays, and bust dart interlining stays shall be black and shall conform to class 1 or 2 of MIL-C-43718.

3.3.6 Cotton wigan cloth. The material for the sleeve bottom interlining shall conform to type I of MIL-C-16375 except that the requirement for breaking strength shall not apply. The color of the material for the sleeve bottom interlining shall be natural.

3.3.7 Wool flannel cloth. The material for the under collar shall conform to A-A-50067 and shall be USAF Color Blue, Shade No. 1578 (see 6.3).

3.3.8 Braid. The braid for the hanger shall be either cotton or rayon, flat braid. The braid shall be 1/8 to 3/16 inch wide, shall have a breaking strength of not less than 50 pounds in the warp direction, shall approximately match the color of the basic fabric or shall be black, and shall show good colorfastness to crocking and wet dry cleaning.

3.3.9 Cotton buckram cloth. The material for the under collar interlining shall conform to type I, class 2, natural or bleached of CCC-C-438 except that the method for shrinkage shall be 5580 of FED-STD-191.

3.3.10 Cotton tape. The tape for the armholes, the gorge, the patch pockets, and the bridle at the break line shall be preshrunk and shall conform to type I, class 1 or 2 of DDD-T-86 except that the requirements pertaining to nonfibrous content shall not apply. The tape for the armholes, the gorge, and the patch pockets shall be 1/4 inch wide and the tape for the bridle at the break line shall be 5/8 inch wide.

3.3.11 Cross-cut tape. The cross-cut tape for the stays for the front interlining, for the back of the neck gorge of the fronts, and for the fronts of the coat shall be made of polyester and cotton twill cloth. The polyester and cotton cloth shall conform to class 2 of MIL-C-43718 except that the requirements for nonfibrous material, seam efficiency, and colorfastness shall not apply and that the cloth shall be undyed or dyed. The cloth shall be cut across the width in strips that are 1/2 ± 1/16 inch wide. The ends of the strips shall be abutted or overlapped and stitched with diagonal stitching. The diagonal stitching shall be a minimum of 8 stitches per inch with a bight (throw) of 1/8 to 3/16 inch. The edges of the cross-cut tape shall be treated with a synthetic resin to prevent raveling.

3.3.12 Labels. The coat shall have a combination personal identification, identification, and instruction label, and a size label conforming to DDD-L-20. The colorfastness to dry cleaning requirements of DDD-L-20 shall apply.

3.3.12.1 Combination personal identification, identification, and instruction label. The combination personal identification, identification, and instruction label for the coat shall conform to type VI, classes 10 and 15 and shall include the following information:

Name
 Service No.
 Coat, Woman's (Pant Suit)
 8410-00-000-0000 (Example) 1/
 DLA-100-00-0-0000 (Example) 1/
 Wool Products Act (information as applicable) 1/
 Contractor 1/

CLEANING INSTRUCTIONS
 DRY CLEAN ONLY

1/ The contractor shall include the applicable information.

3.3.12.2 Size label. The size label shall conform to type VI, class 2. The sizes and lengths (short, regular, and long), shall be abbreviated as follows: 12S, 12R, and 12L.

3.3.13 Threads. All colored threads shall be DoD Shade Navy Blue AT, C.A. 66060 (see DoD Standard Color Card). The dyed thread shall show fastness to light, perspiration, and wet dry cleaning equal to or better than the standard sample (see 6.3). When no standard sample is available, the dyed thread shall show "good" fastness to light, perspiration, and wet dry cleaning.

3.3.13.1 Cotton thread. The cotton thread for seaming the coat shall be type IC2, ticket No. A or B, 3 ply; for edge and top stitching shall be type IC2, ticket No. 00, 3 ply; for seaming the front interlining shall be type IA2 or IB2, ticket No. 70, 2 ply; for tacking sleeves and armholes shall be type IA2 or IB2, ticket No. 30, 3 ply; for sewing on buttons shall be type IA3 or IB3, ticket No. 12, 16 or 20, 4 ply; and for quilting and blindstitching shall be type IA2 or IB2, ticket No. 70, 2 ply conforming to V-T-276.

3.3.13.2 Silk thread. The silk thread for hand felling shall be type III, ticket A or C; for machine felling shall be type I, tickets A and O; and for sewing the buttonholes shall be type I, tickets A, B, and C conforming to V-T-301.

3.3.13.3 Polyester thread. The polyester thread for padding the lapels and the bridle, if used, and for machine felling and blindstitching shall conform to type I, class 1, letter size A of V-T-285.

3.3.13.4 Nylon thread. The nylon thread for hand felling shall conform to type IV, sizes A and C, 2 ply of V-T-295. If an automatic machine that sews shank buttons imitating hand sewing is used, the thread shall be nylon waxed monocord, special no. 4, having a breaking strength of 11 pounds and a minimum length per pound of 3,250 yards. The nylon thread for machine felling and for sewing buttonholes shall be a nylon, tailoring, soft finish thread conforming to the requirements specified in table I. The nylon thread shall have good colorfastness to wet dry cleaning, light, and perspiration when tested as specified in V-T-295.

3.3.13.5 Temporary basting. Except for the option that is specified in 3.3.13.5.1, the thread for temporary basting shall be a commercial cotton or the same thread that is used in seaming coats.

3.3.13.5.1 Monofilament synthetic thread. A monofilament synthetic thread may be used for only the basting operations where the thread is required to be removed. If a monofilament synthetic thread is used, the coat shall subsequently be given a treatment with a dry cleaning agent in which the monofilament synthetic thread is soluble. Any residue remaining on the coat after the dry cleaning process shall be brushed off or removed.

TABLE I. Nylon thread.

Size <u>1/</u>	Ply	Minimum Length Per Pound (Yards)	Minimum Breaking Strength (Pounds)	Maximum Elongation (Percent)
O	2	16,000	3.0	35
B	2	11,000	4.0	35
F	2	3,800	12.0	35

1/ Size O shall be used for machine felling and sizes B and F shall be used for sewing buttonholes.

3.3.14 Gimp. The gimp for reinforcing the buttonholes shall be a no. 3 silk gimp with a cotton core, soft or hard finish or cotton conforming to type II, size 8 of V-T-280. The gimp shall be 100 \pm 5 yards per ounce. The color of the gimp shall approximately match the basic fabric and shall have good colorfastness to dry cleaning.

3.3.15 Shoulder pads. The shoulder pads shall conform to type III, class 4 of MIL-P-15064 or they shall be commercially made needle punch shoulder pads conforming to all of the applicable requirements for type III, class 4 of MIL-P-15064 except for the following requirements: The commercially made needle punch shoulder pads shall consist of three plies of polyester wadding, 4.5 ounces per square yard, and one ply of interlining that is 5 inches long by 2-1/4 inches wide. The interlining shall be placed between the top ply and the second ply of the polyester wadding.

3.3.16 Buttons. The buttons shall conform to type I, style 1, size 30 lines, hopper back or short shank of MIL-B-3461.

3.4 Design. The coat shall be semi-fitted, single-breasted, and fully lined. The coat shall have a three-button front closure, shoulder loops, semi-peak lapels, an open collar, and two lower front patch pockets.

3.5 Patterns. Standard patterns shall be furnished by the Government. The standard patterns show size, seam allowances, shape and placement of patch pockets, directional lines for cutting, and are marked or notched for proper placement and assembly of the component parts. The standard patterns have a seam allowance of 3/4 inch for the center back seam, for the seams joining the backs to the sides, and for the seams joining the side lining to the back lining; 3/8 inch for the seams joining the sides to the fronts and for the seams joining the side lining to the front lining; 1/4 inch for sewing the facing to the fronts except for sewing the assembled lining to the back edge of the front facings to the notch at the bottom of the front facings; 1/2 inch for the center back lining seams; and 3/8 inch for sewing the assembled lining to the back edge of the facings to

the notch at the bottom of the front facings and for any other seams. The standard patterns shall not be altered in any way and are to be used as a guide for cutting the contractor's working patterns. The working patterns shall be identical to the Government patterns.

3.5.1 Pattern parts. The component parts of the coat shall be cut from the materials specified in accordance with the number of parts indicated in table II.

3.6 Construction. The construction of the coat shall conform in all respects to the requirements specified in table III and herein. Figures are furnished for guidance and information only. If there are any inconsistencies between the specification and the figures, the specification shall govern.

3.6.1 Stitches, seams, and stitchings. All stitches, seams, and stitching shall conform to FED-STD-751. The type of seams, stitchings, and stitches per inch shall be as specified in table III. Seam allowances shall be maintained with seams sewn so that no raw edges, run-offs, pleats, puckers, or open seams occur. When two or more seam or stitch types are specified for the same part of the operation, any one may be used. Where stitch type 401 is used, the looper (underthread) shall be on the inside of the coat.

3.6.1.1 Type 301 stitching. The ends of all stitchings shall be backstitched or overstitched not less than 1/4 inch except where ends are turned under or caught in other seams or stitching. The ends of a continuous line of stitching, except on labels, shall overlap not less than 1/2 inch. The ends of continuous lines of stitching on labels shall be overlapped not less than three stitches. Thread breaks (all stitch types) shall be secured by stitching back of the break not less than 1/2 to 1 inch.

3.6.1.1.1 Repairs of type 301 stitching. Repairs of type 301 stitching shall be as follows:

a. When thread breaks, skipped stitches, run-offs, or bobbin runouts occur during sewing, the stitching shall be repaired by superimposing and restarting the stitching a minimum of 1/4 inch back of the end of the stitching (see NOTE).

b. Except for prestitching, thread breaks, two or more consecutive skipped or run-off stitches noted during inspection of the item (in-process or end item) shall be repaired by overstitching. The stitching shall start a minimum of 1/4 inch in back of the defective area, continue over the defective area, and continue a minimum of 1/4 inch beyond the defective area onto the existing stitching. Loose or excessively tight stitching shall be repaired by removing the defective stitching without damaging the materials and restitching in the required manner (see NOTE).

NOTE: When making the above repairs, the ends of the stitching are not required to be backstitched.

TABLE II. List of pattern parts.

Material	Pattern Nomenclature	Cut Parts
Basic cloth (see 3.3.1)	Front	2
	Back	2
	Top sleeve	2
	Under sleeve	2
	Top collar	1
	Shoulder loop	2
	Front facing	2
	Side	2
	Patch pocket	2
Rayon cloth (see 3.3.2)	Front lining	2
	Side lining	2
	Back lining	2
	Top sleeve lining	2
	Under sleeve lining	2
Cotton-warp, hair- wool filling cloth (see 3.3.3)	Front interlining	2
	Shoulder loop interlining	2
Polyester and cotton twill cloth (see 3.3.5)	Patch pocket lining	2
Cotton wigan cloth (see 3.3.6)	Sleeve bottom interlining	2
Wool flannel cloth (see 3.3.7)	Under collar <u>1/</u>	2
Cotton buckram cloth (see 3.3.9)	Under collar interlining <u>1/</u>	2
Shapers	Finished shoulder loop	
	Finished collar and lapel <u>2/</u>	
	Lapel	
	Finished patch pocket	
Marker	Bust dart	

1/ One part with the center seam allowance omitted may be cut in lieu of two parts.

2/ The finished collar and lapel shaper shall be separated at the gorge line into two parts.

3.6.1.2 Types 101, 102, 103, 304, 306, 401, and 801 stitching. Thread tension shall be maintained so that there will be no loose or excessively tight stitching resulting in puckering of the material. All repairs shall be in accordance with 3.6.1.1.1. Type 301 stitching may be used to repair type 401 stitching.

3.6.1.3 Automatic stitching. Automatic machines may be used to perform any of the stitch patterns provided the requirements for the stitch patterns, stitches per inch, and size and type of thread are met; and at least three tying, overlapping, or backstitches are used to secure the ends of stitches.

3.6.1.4 Thread ends. All thread ends shall be trimmed to 1/4 inch maximum length.

3.7 Manufacturing operations requirements. The coat shall be manufactured in accordance with operation requirements specified in table III. The contractor is not required to follow the exact sequence of operations listed unless otherwise specified. Any additional basting or holding stitches used to facilitate manufacture are permissible provided the thread is removed or does not show in the finished coat.

3.7.1 Shade and size marking. The component parts of the coat shall be marked, ticketed, or bundled to insure a uniform shade and size. Any method may be used except:

- a. Corrosive metal fastening devices.
- b. Adhesive type tickets which discolor or adhere to the material upon removal of tickets.

NOTE: The use of an ink pad numbering machine, rubber stamp, or pencil is allowed provided the numbering does not show on the outside of the coat and wherever possible is covered by the seam allowance.

3.7.2 Pressing. Unless otherwise specified herein, all pressing shall be accomplished by a heated pressing iron or machine. A steam pressing machine shall be used for Operations 15.a, 20, and 36.a through 36.k of table III.

3.8 Finished measurements. The measurements of the finished coat shall conform to the requirements specified in table IV.

3.9 Workmanship. The finished coat shall conform to the quality of product established by this document. The occurrence of defects shall not exceed the acceptable point value.

TABLE III. Manufacturing operations.

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
1.	<p><u>Cut parts.</u></p> <p>a. Cut the parts of the coat as specified herein and in strict accordance with the patterns which show size, directional lines for cutting, markings, and notches for assembly of all parts. Mark each part in the top ply of the main lay of each material with the size of the coat. Do not use drill marking, perforated paper markers, or plain paper markers on the basic fabric. Felt back paper markers may be used on the basic fabric.</p> <p>b. Spread the basic fabric face to face, that is, with the face of one ply over and against the face of the next ply below. Take care in spreading the basic fabric so that the plies are not stretched and so that one side of the lay is even. Lay up the basic fabric in uniform widths and lengths not more than 80 single plies (40 coats) high. Cut all parts that are made of the basic fabric from one piece of the basic fabric. Cut the top collar and the shoulder loops across the width of the basic fabric.</p> <p>c. Unless otherwise specified herein, cut all parts of the coat that are made of the rayon cloth from one piece of rayon cloth. The sleeve lining may be cut from ends of the rayon cloth provided that the parts of sleeve lining match each other in shade and match the other parts cut of the</p>					

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
1.	<p><u>Cut parts.</u> - Contd</p> <p>rayon cloth in shade. Cut the parts of the lining with the directional lines on the patterns in the warp direction of the rayon cloth.</p> <p>d. Cut the front interlining from the cotton-warp, hair-wool-filling cloth in the direction of the warp. Cut the shoulder loop interlining from the cotton-warp, hair-wool-filling cloth in accordance with the directional lines on the pattern.</p> <p>e. Cut the under collar interlining from the cotton buckram cloth in accordance with the directional lines on the pattern. The under collar interlining may be cut in one piece with the center seam allowance omitted.</p> <p>f. Cut the sleeve bottom interlining from the cotton wigan cloth in accordance with the directional lines on the pattern.</p> <p>g. Cut the under collar from the wool flannel cloth in accordance with the directional lines on the pattern. The under collar may be cut in one piece with the center seam allowance omitted.</p> <p>h. Cut the patch pocket lining with the directional lines on the patterns in the warp direction of the polyester and cotton twill cloth.</p>					

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
2.	<u>Replace defective parts.</u> Remove any parts containing material defects or workmanship damages that are classified as defects in MIL-STD-1608 from production during the spreading, cutting, and manufacturing process and replace with nondefective and properly matched parts.					
3.	<u>Mark parts.</u> Mark, ticket, or bundle the cut parts to insure a uniform shade and size throughout the coat (see 3.7.1). Sew-on type tickets may be used to shade mark the basic fabric. Parts that are cut from ends, except the sleeve lining, need not be shade marked. Shade mark the parts of the sleeve lining whether cut from ends or in the main lay. Start the numbering for all parts at all times from the same position; for example, if the top ply is numbered one, all parts in the top ply and the next ply below shall be numbered one.					
4.	<u>Make sleeves.</u> a. Join the forearm of each sleeve with a 3/8-inch seam. b. Press the forearm seam of each sleeve open and flat, holding the folding line of the top sleeve short.	301	SSa-1	10-14	A	A

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
3.	<u>Make sleeves.</u> - Contd					
	c. Stitch the sleeve interlining to the underarm seam and the sides of the backarm seam so that the bottom edge of the sleeve interlining will be 1/2 to 3/4 inch below the turn-up notches.	301	SSa-1	6-14	A	A
	d. Mark and baste the turn-up of each sleeve.	101 or Hand				
	e. Press the bottom of each sleeve. Remove the basting.					
	f. Join the backarm of each sleeve.	301	SSa-1	10-14	A	A
	g. Press the backarm seam of each sleeve open and flat holding the seam short.					
	h. Blindstitch the turn-up of each sleeve to the sleeve interlining.	101 or 301 or Hand	EFc-1(b)	4-6 4-6 1-2	70 70 70	70
	i. Join the backarm of each sleeve lining with a 3/8-inch seam. Join the forearm of each sleeve lining with a 3/8-inch seam.	301 or 401	SSa-1	10-14	A	A
	NOTE: The sleeve lining shall extend not less than 3/4 inch nor more than 1 inch above the top of each sleeve.					
	j. Tack the forearm and backarm seams of the sleeve lining to the forearm and backarm seams of the sleeve, respectively, distributing the fullness of the sleeve	301 or 401 or Hand	SSa-1	4-6 1/2-1	A 30	A

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
4.	<u>Make sleeves.</u> - Contd lining during the tacking operation. If the tacking is done by hand, securely backstitch both ends of the hand stitching with not less than three stitches. NOTE: The tacking shall extend from not more than 5 inches below the top of the sleeve to not more than 5 inches above the creased bottom edge. k. Baste the turn-up of each sleeve lining. NOTE: The turn-up of the sleeve lining shall be not less than 1 inch.	Hand or 101				
5.	<u>Make collar</u>					
	a. Join the under collar.	301	SSa-1	12-14	A	A
	b. Join the under collar interlining.	301	LSa-1	12-14	A	A
	c. Open the under collar seam and stitch one side of the seam allowance to the under collar interlining, or press the under collar seam open.	301	SSa-1	6-8	A	A
	d. Quilt the under collar interlining to the under collar with seven or eight rows of blind-stitching.	103	SSm-7 or SSm-8		70	

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
5.	<p><u>Make collar.</u> - Contd</p> <p>NOTE: If the under collar and the under collar interlining are cut in one piece, Operations 5.a, 5.b, and 5.c will not be required. If the under collar and the under collar interlining are not cut in one piece, Operations 5.a, 5.b, and 5.c shall be performed before Operation 5.d.</p> <p>e. Press the under collar.</p> <p>f. Shape and trim the under collar. Trim the under collar interlining 1/8 inch away from the lower edge of the under collar. The under collar may be die shaped to conform to the finished collar and lapel shaper.</p> <p>g. Mark the under collar stand.</p> <p>h. Stitch the stand of the under collar. Stitch the top and the side edges of the under collar 1/2 <u>+1/8</u> inch from the edge.</p> <p>NOTE: The width of the stand at both shoulders and the center shall be 1-1/8 <u>+1/8</u> inches.</p> <p>i. Mark the top collar with the finished collar and lapel shaper. The top collar may be die cut as indicated by the finished collar and lapel shaper at the outer edge.</p>					
		301	SSa-1	12-14	A	A
		301	SSa-1	12-14	A	A

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
5.	<u>Make collar.</u> - Contd					
	j. Position the upper edge of the top collar between the upper edges of the under collar and the under collar interlining, matching the notches, and seam together.	301	LSa-1	4-6	A	A
	NOTE: When the option specified in Operations 5.o or 5.p is used, the top collar does not need to be sewn to the under collar interlining.					
	k. Baste the upper edge of the collar and at the creaseline.	101 or Hand				
	OR					
	l. In lieu of Operations 5.j and 5.k, baste top collar to the under collar along creaseline in the outer edge, matching the notches.	101 or Hand				
	m. Trim and turn the edges of the top collar over the under collar interlining, between the under collar and the under collar interlining, and baste the edges.	Hand or Machine				
	n. Fell the top and side edges of the top collar to the under collar.	Hand		8-10	A or C Nylon	
	OR					
	o. As an option to Operation 5.n, fell the top edge only of the top collar to the under collar by machine with simulated hand stitching. Fell the corners and the sides of the top collar to the under collar by hand.	Machine Hand		6-10 8-10	A A or C Nylon	A

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
5.	<p><u>Make collar.</u> - Contd</p> <p>OR</p> <p>p. As an option to Operation 5.n, fell the top edge only of the top collar to the under collar by machine with simulated hand stitching. Stitch the side edges of the top collar to the under collar through the under collar interlining, by machine, 1/16 inch from the finished shaped edge.</p> <p>NOTE: The option to fell the top edge of the collar by machine as specified in Operations 5.o or 5.p, if used, shall be performed before the collar is basted.</p> <p>q. Trim the top collar only 1/4 to 3/8 inch from the finished seam line.</p> <p>r. Trim the bottom edge of the top collar to allow for seaming.</p> <p>s. As an option to Operations 5.j through 5.r, make the collar as follows:</p> <p>(1) Insert the bias binding that is 1/2 by 3/4 inch and that is made of the rayon cloth specified in 3.3.2 between the under collar and the under collar interlining so that the bias binding will extend approximately 1/4 inch from the outer edge of the collar, and stitch through the three plies.</p>	Machine		6-10	A	A
		304 or 306		12-14	A	A

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
5.	<u>Make collar.</u> - Contd (2) Stitch the under collar to the top collar, using a 3/16-inch knife attachment, matching the notches and distributing fullness. NOTE: The edge of the under collar interlining shall be used as a guide for the finished stitch line and the shape of the collar. (3) Turn the collar. Force out the edges. Baste the edge of the collar with at least two rows of stitching, distributing the collar fullness evenly and rolling the joining seam to the underside, with the first row of stitching 1/4 inch from the edge and the other row of stitching along the outside edge of the collar. NOTE: The rayon bias binding shall not be exposed at the edge of the finished collar.	301	SSa-1	12-14	A	A
		Hand or Machine			Commer- cial Cotton	
6.	<u>Make patch pockets.</u> a. Stitch the 1/4-inch-wide tape to the top of each patch pocket at the top of the hem as indicated by the pattern. b. Position the pocket lining at the top of each pocket, face to face, and stitch the pocket lining to the pocket 3/8 inch from the raw edges.	301	SSaa-1	10-12	A	A
		301	SSa-1	10-14	A	A

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
6.	<u>Make patch pockets.</u> - Contd					
	c. Fold the patch pocket lining down, forming a hem at the top that is $3/4 + 1/8$ inch wide.					
	d. Stitch the raw edges of the sides and the bottom of each patch pocket $1/8$ to $3/16$ inch from the edge.	301	SSa-1	10-14	A	A
7.	<u>Make lining.</u>					
	a. Fold the shoulder darts in the lining, as indicated by the pattern notches, and stitch the darts across the shoulders.	301 or 401	SSa-1	10-14	A	A
	b. Fold the bust darts in the front lining, forming a pleat in accordance with the notches and the depth of the dart in the front. Sew across the pleat along the side seam.	301 or 401	SSa-1	10-14	A	A
	c. Fold and stitch the vertical dart in the front lining as indicated by the pattern marks.	301 or 401	OSf-1	10-14	A	A
	NOTE: The outside (face of the rayon cloth) fold of the pleats shall be toward the bottom of the coat. The bust dart pleats may be formed as part of Operation 7.g when the front lining is joined to the side lining. The shoulder pleats and vertical darts shall be folded toward the side seam.					

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
7.	<u>Make lining.</u> - Contd					
	d. Join the center back lining seam with a 1/2-inch gage. Form a 7/8- to 1-inch pleat the full length of the lining and stitch across the neck end.	301 or 401	SSa-1	10-14	A	A
	NOTE: The outside of the folded edge of the pleat shall be turned toward the right side.					
	e. Join the side lining to the back lining with a 3/4-inch seam.	301 or 401	SSa-1	10-14	A	A
	f. Join the front lining to the side lining with a 3/8-inch seam.	301 or 401	SSa-1	10-14	A	A
	g. As an option to Operations 7.b and 7.f join the front lining to the side lining with a 3/8-inch seam, forming a bust dart at the notches of the front lining.	301 or 401	SSa-1	10-14	A	A
	h. Stitch the assembled lining to the back edge of the front facing, with a 3/8-inch seam, to the notch at the bottom of the front facings.	301 or 401	SSa-1	10-14	A	A
8.	<u>Press lining.</u>					
	a. Press all lining seams flat, except the center back seam of the lining, toward the center of the back.					
	b. Press the seams joining the lining to the front facing flat to one side toward the side seam.					

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
8.	<p><u>Press lining.</u> - Contd</p> <p>c. Fold the back edge of the front facing seam allowance toward the front edge. Press the seam allowance for a distance of approximately 3-1/2 inches from the bottom of the front facing.</p> <p>d. Press each bust dart and each shoulder dart in the lining, forming a pleat, with the front end of the dart (pleat) tapering to nothing.</p> <p>NOTE: As an option to Operation 8.d, the bust darts and the shoulder darts may be pressed in the finish pressing of the body lining specified in Operation 36.k.</p>					
9.	<p><u>Attach label.</u></p> <p>a. Place the combination personal identification and identification label on the front facing of the left front 8 inches from the bottom of the coat and 1/4 inch from the front facing seam line.</p> <p>b. Stitch the combination personal identification and identification label on all four sides not less than 1/16 inch and not more than 1/8 inch from the edge.</p>	301	SSa-1	10-14		
10.	<p><u>Make front.</u></p> <p>a. Stitch each bust dart, with a 3/8-inch seam, tapering to nothing, 3/4 inch beyond the end of the cut as indicated on the pattern.</p>	301	SSa-1	10-14	A or B	A or B

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
10.	<p><u>Make front.</u> - Contd</p> <p>b. Press each bust dart flat.</p> <p>c. Seam each front vertical uncut dart, with a 1-inch-wide strip of the basic fabric that has been cut in the warp direction, so that the seam will be 1/4-inch gage at the center of the dart and will taper off at each end as indicated by the marks on the pattern.</p> <p>NOTE: Each strip shall extend at least 1/4 inch beyond the ends of the stitching and shall face towards the front when the front vertical uncut dart is pressed flat.</p> <p>d. Press the dart seams open and flat, holding the front vertical uncut darts short and curved toward the front edges at the center.</p> <p>e. Join the sides to the fronts, with 3/8-inch seams, matching the notches as indicated by the marks on the patterns.</p> <p>f. Mark each bust dart on the reverse side of the fronts with the bust dart marker.</p> <p>g. Press the seams joining the sides to the fronts open and flat.</p>	301 or 401	SSa-1	12-14	A	A
	<p>e. Join the sides to the fronts, with 3/8-inch seams, matching the notches as indicated by the marks on the patterns.</p> <p>f. Mark each bust dart on the reverse side of the fronts with the bust dart marker.</p> <p>g. Press the seams joining the sides to the fronts open and flat.</p>	301	SSa-1	10-14	B	B
11.	<p><u>Attach patch pockets.</u></p> <p>a. Mark the position of each patch pocket on the front as indicated by the marks on the patterns.</p>					

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
11.	<u>Attach patch pockets.</u> - Contd					
	b. Sew each patch pocket to the front at the marks, with the ends of the stitching securely tacked, catching the pocket stay at the underside of the front adjacent to the top corners of the pocket in the stitching.	301	LSb1-2(a)	10-14	A	A
	c. Press each patch pocket flat.					
	d. Top stitch the sides and the bottom of each patch pocket 3/8 inch from the folded edge. Securely tack the ends of the stitching.	301	LSb1-2(b)	10-14	A	A
	NOTE: Each patch pocket shall conform to the finished patch pocket shaper.					
12.	<u>Make interlining for fronts.</u>					
	a. Abut the edges of each bust dart in the front interlining. Zigzag stitch the abutted edges of the bust dart in the front interlining together through the bust dart interlining stay.	304	FSa-1	4-8	70	70
	b. Zigzag stitch the abutted edges of each bust dart in the front interlining together. Stitch the bust dart interlining stay to each side of the abutted edges of each bust dart in the front interlining.	304 and 301 or 304	FSd-3	4-8 10-14 4-8	70 A 70	70 A 70
	c. Press the front interlining on a shape pressing machine.					

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
13.	<u>Baste front interlining to fronts.</u>					
	a. Baste the front interlining, to each front, from below the shoulder to the bottom of the coat at the center, matching the bust darts in the front interlining with the bust darts in the front of the outer shell horizontally and vertically.	301 Hopper or Hand		1-2 1-2		
	NOTE: The front interlining shall extend beyond the full length of the front and beyond the armholes and the shoulders.					
	b. Baste the lapel break line across the shoulder and around the armhole. Continue the basting along the side of the front interlining to the bottom.	301 Hopper or Hand		1-2		
	c. Baste along the break line of each lapel. Continue the basting down the fronts.	301 Hopper or Hand		1-2		
	d. Baste the 5/8-inch-wide tape at the bridle, holding the tape taut and with the fullness on the fronts evenly distributed at the bust area only.	101 or 301 Hopper or Hand		4-6 2 2	A	A
	NOTE: The 5/8-inch-wide tape shall be adjacent to but behind the break line of the lapel and shall extend above the gorge seam at least 1 inch and within 2 to 2-1/2 inches of the front edge at the bottom point.					

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
13.	<u>Baste front interlining to fronts.</u> - Contd					
	e. Stitch the interlining at the front armhole seam and the shoulder seam 1/8 to 3/16 inch from the edge. Trim the excess interlining material at the shoulders, the armholes, and the gorge.	301	SSa-1	10-14	A	A
	f. Sew a 1/4-inch-wide tape to each armhole seam 1 inch above the seam that joins the side to the front to within 3/4 inch of the side back joining seam.		SSaa-1	8-12	A	A
14.	<u>Pad lapels.</u>					
	a. Pad each lapel to the front interlining with five to six rows of blindstitching, with fullness in the front interlining between the rows of stitching, allowing the lapel to roll.	103 or	SSm-5 or SSm-6	4-6	A or A Poly- ester	A
		301	SSm-5 or SSm-6	4-6	A or A Poly- ester	A
	b. Stitch the 5/8-inch-wide tape 3/8 to 1/2 inch back of the break line of each lapel with a row of blindstitching on each edge.	103 or 301	SSm-2 SSm-2	4-6 4-6	A A	A A
15.	<u>Press and shape fronts.</u>					
	a. After the lapels have been padded, press the right front, the left front, the lapels, and the bust of the coat individually to the shape of the body on a steam pressing machine. If the fronts are not pressed on a right and					

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
15.	<p><u>Press and shape fronts.</u> - Contd</p> <p>left form pressing machine, manipulate the fronts during the pressing to retain the shapes.</p> <p>NOTE: The front edge shall effect a straight line from the top button to within 3 inches of the bottom of the finished coat.</p> <p>b. Position the top of the lapel working shaper at the breakline mark located at the lapel gorge 1/4 inch in front of the neck gorge step and at the bottom of the breakline even with the front edge adjacent to the end of the breakline, and mark at the top and the side of each lapel. Shape each lapel as marked. Trim the front interlining 3/8 inch away from the edge of the lapels, the fronts, and the bottom.</p>					
16.	<p><u>Baste front facing to fronts.</u></p> <p>Match and fit the front facing to each front. Baste the front facing to the front, placing fullness over the bust area and the lapels.</p> <p>NOTE: The front vertical uncut darts and the bust darts in the lining shall be aligned horizontally and vertically with the front vertical uncut darts and the bust darts in outer shell.</p>	Hand or 301 Hopper		1-2		

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
17.	<u>Tape and stitch front edges.</u>					
	a. Stitch the cross-cut tape and the front facing to the edge of each front, with a 1/4-inch seam, from the lapel notch across the top of the lapel, down the front, and across the front facing. The edge may be trimmed, with a knife attachment, not less than 3/16 inch from the stitching.	301	SSab-1	10-14	A	A
	b. Blindstitch the back edge of the tape to the front interlining from the lapel notch to the back edge of the front facing.	103 or Hand	SSa-1	3-4 3-4	70	
18.	<u>Make back.</u>					
	a. Join the center back seam with a 3/4-inch seam.	301	SSa-1	10-14	B	B
	b. Seam the cross-cut tape across the neck of the back to within 1/2 inch at each shoulder part.	301	SSaa-1	10-14	A	A
	c. Sew the 1/4-inch-wide tape to each armhole of the back, from the side seam to within 3/4 inch of the shoulder, holding the tape taut to draw up the material mainly at the shoulder-blade area.	301 or 401	SSaa-1	10-14	A	A
	d. Press the center back seam open and flat.					
19.	<u>Join back to sides.</u>					
	a. Join the back to the sides with a 3/4-inch seam, matching the notches as indicated by the marks on the pattern.	301	SSa-1	10-14	B	B

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
19.	<u>Join back to sides.</u> - Contd					
	b. Press the seams joining the back to the sides open and flat.					
20.	<u>Press edges.</u>					
	a. Press the edges of the lapels and the fronts flat and smooth on a steam pressing machine. Remove the basting.					
	b. Press the lapel and the front edge seams open and flat on a steam pressing machine.					
21.	<u>Hem bottom.</u>					
	a. Turn up the bottom of the coat $1\frac{3}{8}$ \pm $\frac{1}{8}$ inches and baste. Continue the basting across the bottom of the front facing.	101 or Hand				
	b. Blindstitch the hem to the bottom of the coat and to the seam outlets.	103	SSm-1	4-6	70	
22.	<u>Trim, turn, and baste fronts.</u>					
	a. Slash the seam allowance at the step notch at the top of each lapel facing. Force out the lapel points, the lapels, and the front edges. Baste the edges around the lapels and down the fronts, rolling the joining seam along the front toward the inside of the coat and rolling the joining seam along the lapel edge toward the underside of the lapel.	101 or Hand		2-4 2		

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
22.	<u>Trim, turn, and baste fronts.</u> - Contd					
	b. Baste a second row of stitching approximately 3/4 inch from the front edge.	Hand or 301 Hopper		1-2 inches long		
	c. Place a diagonal row of basting from the lapel break line to the point of the lapel.	Hand or 301 Hopper		1-2 inches long		
	d. Baste the break line of the lapels, allowing proper fullness for the roll of the lapel.	Hand or 301 Hopper		1-2 inches long		
	e. Baste along the back edge of the front facing, putting fullness in the bust area.	Hand or 301 Hopper		1-2 inches long		
	f. Tack the back edge of the front facing to the front interlining by blindstitching, starting not more than 3 inches from each shoulder and extending to not less than 2 inches from the bottom. Securely tack the ends of the stitching.	Hand or 103 or 301	SSm-1 SSm-1	1-2 4-6 4-6		
23.	<u>Baste lining.</u>					
	a. Baste around each armhole of the front lining to the side seam, along the side seam to approximately 4 inches from the bottom of the finished coat, and across the bottom of the front lining.	Hand or 301 Hopper				
	b. Baste around each armhole (back) and across the shoulder area and the neck, forming a 7/8- to 1-inch pleat in the center of the back lining.	Hand or 301 Hopper				

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
23.	<u>Baste lining.</u> - Contd NOTE: The pleat shall face the right armhole. c. Trim the bottom of the lining (if necessary). d. Turn in the bottom of the lining so that the lining will be not less than 1/2 inch nor more than 3/4 inch from the bottom of the finished coat and baste. e. Trim the front facing and the front interlining at the gorge, allowing for the seam for setting the collar. f. Trim the lining around the armholes and the shoulders, allowing sufficient material to accomplish the subsequent operations.					
24.	<u>Join shoulders.</u> a. Join each shoulder with a 3/8-inch seam. b. Press each shoulder seam open and flat, without stretching the seam.	301	SSa-1	10-14	B	B
25.	<u>Baste shoulder interlining.</u> Turn under the edges of the back lining at each shoulder. Baste the upper part of each shoulder. Continue the basting across the neck at the back, with the back lining extending into the neck outlet.	Hand or 301 Hopper				

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
26.	<u>Set on collar.</u>					
	a. Chalk mark the neck outlet on the back and the front of the gorge, as indicated by the pattern, 5/8 inch at the back and shoulder seams, tapering to 3/8 inch at the lapel break line and the step notch of the lapel.					
	b. Join the topcollar to the front facing at the gorge from the end of the lapel step to a point not less than 1 inch back of the lapel break line.	301	SSa-1	10-14	A	A
	c. Slash the seam allowance of the front facing at the end of the stitching. Spread open the gorge seam, and tack the top collar seam allowance through all plies.	301		10-14	A	A
	d. Center, $\pm 1/2$ inch, the size label and the hanger (with the ends spread apart) on the back lining, and stitch the size label and the hanger.	301		10-14	A	A
	NOTE: The finished hanger shall be spread apart and shall be 2 $\pm 1/2$ inches long, when it is measured from the bottom of the top collar to the outer edges of the hanger.					
	e. Baste the lower edge of the under collar to the neckline and the gorge, as indicated by the chalk mark, putting in proper fullness over the shoulder seam area.	Hand		2-4		

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
26.	<u>Set on collar.</u> - Contd					
	f. Tack the neck outlet, across the back, to the collar interlining.	Hand or 103	SSa-1	4-6		
	g. Turn under the neck edge of the top collar, and baste between the ends of the gorge seam of the front facing.	Hand or 301 Hopper				
	OR					
	h. In lieu of Operations 26.a, 26.e, 26.f, and 26.g, stitch the lower edge of the top collar across the neck from gorge seam to gorge seam. Adjust the collar to accomodate a 3/8-inch seam at the lower end of the top collar and to maintain a 5/8-inch outlet at the neck as required when applying the under collar.	301	SSa-1	10-14	A	A
	i. Fell the lower edge of the under collar of the coat.	Hand or Machine (hand-type felling or 306)		8-10	C Nylon A	A
	NOTE: The raw edge of the under collar shall be enclosed within the felling.					
	j. Securely tack the corners of the collar across the juncture point of the collar and the lapel.	Hand		6-8	C Nylon	

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
27.	<u>Make shoulder loops.</u>					
	a. Fold each shoulder loop, and stitch the raw edges of the side. Spread each seam off center, and stitch the round end of each shoulder loop.	301 or 401	SSa-1	10-12	A	A
	b. Press the shoulder loop seams open and flat.					
	c. Stitch the shoulder loop interlining to each shoulder loop seam.	301	SSa-1	8-10	A	A
	OR					
	d. Blindstitch the shoulder loop interlining to the side edges of each shoulder loop.	103 or 301	SSm-1 SSm-1	4-6 4-6	A A	A
	e. Turn and press each shoulder loop smooth and flat.					
	NOTE: The shoulder loop seam shall be on the underside, off center of the shoulder loop.					
	f. Stitch around the edges of each shoulder loop with a single row of stitching 3/8 inch from the edge.	301	OSf-1 and SSe-2(b)	10-14	A	A
	NOTE: The shoulder loop interlining shall lie smooth in the shoulder loops and shall be caught in the edge stitching. The finished shoulder loops shall conform to the finished shoulder loop marker.					

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
28.	<u>Set shoulder loops.</u> Baste or stitch each shoulder loop to the shoulder at the armhole. Trim each shoulder loop even with the armhole. NOTE: The round end of each shoulder loop shall be even with the edge of the gorge outlet. The long side of each shoulder loop shall be placed towards the back of the shoulder seam as indicated by the marks on the pattern. Each shoulder loop shall be centered, $\pm 1/8$, on the shoulder seam. Each finished shoulder loop shall be $2-3/8 \pm 1/8$ inches wide at the sleeve head.	301	SSa-1	6-8	A	A
29.	<u>Set in sleeves finished appearance.</u> a. The sleeves shall set uniformly with fullness at armhole distributed without pleats or puckers. b. Match and stitch in each sleeve, notch to notch, with a $3/8$ -inch seam, distributing the fullness and catching the end of the shoulder loop in the seam.	301 or 401	SSa-1	10-14	B	B
30.	<u>Press armhole seams and set shoulder pads.</u> a. Press the fullness of each sleeve flat all around the armhole.					

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
30.	<u>Press armhole seams and set shoulder pads.</u> - Contd					
	b. Place the shoulder pads on the interlining so that the center of each shoulder pad will be $3/4 + 1/4$ inch forward of the shoulder seam line in the finished coat with the straight edge of the shoulder pad even with the armhole seam allowance. Securely tack each shoulder pad to the shoulder seam outlet at the back end around the top part of the armhole seam outlet.	Hand or 301 Hopper		1-2 2-4		
	c. Baste around each armhole, positioning the body lining in the proper location. Turn under the back shoulder lining over the front shoulder lining at the proper location and baste.	Hand or 301 Hopper		1-2 2-4		
31.	<u>Tack armholes.</u>					
	a. Tack all around each armhole, backstitching the tacking every other stitch from the front notch across the top of the armhole to the side seam.	Hand		3-4	30	30
	b. Tack the base of each armhole from the sleeve notch on the front to the sleeve notch on the back.	301	SSa-1	6-8	A	A
	OR					
	c. As an option to Operations 31.a and 31.b, tack all around each armhole, from the front notch across the top of the armhole, to the side seam, by machine with a loosely formed and elastic stitch.				30	30

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
31.	<u>Tack armholes.</u> - Contd d. Trim away the excess lining and interlining. e. Tack the sleeve head wadding through each armhole seam allowance not more than 1/8 inch from the seam stitching from the front armhole notch to the back seam of the sleeve. If the armhole is tacked by machine, tack the armhole and the sleeve head wadding simultaneously.	Hand or 301		3-4 4-6	30	30
32.	<u>Stitch front and collar edges.</u> Stitch the edges of each front and the collar 3/8-inch gage. Continue the stitching across the bottom of each front the width of the facing.	301	Similar to SSe-2(b)	10-14	A Silk or Nylon or 00 Cotton	
33.	<u>Fell lining.</u> a. Fell the lining all around each armhole, working in the fullness evenly between the notches, with the sleeve edge turned under and with the forearm and the back arm seam lines in the sleeve lining and the sleeves aligned. Backstitch each armhole at the armpit from the forearm seam of the sleeves to the side seam. OR	Hand		6-8	A or C Silk or A or C Nylon	

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
33.	<u>Fell lining.</u> - Contd					
	b. As an option to Operation 33.a, stitch the sleeve lining to the armhole on the inside from the forearm seam across the under-sleeve, and fell the top portion by machine with simulated hand felling.	301	SSa-1	10-14	A	A
	NOTE: Simulated hand felling shall be accomplished from the outside of the armhole.					
	c. Fell the sleeve lining at the turn-up.	Hand		6-8	A or C Silk or A or C Nylon	
	OR					
	d. Fell the sleeve lining to the bottom of each sleeve.	306		6-8	O Silk or O Nylon or A Polyester	
	e. Fell the lining of the shoulders and the lower edge of the top collar from the back end of the gorge to the back end of the gorge seam, catching the hanger and the size label.	Hand		6-8	A or C Silk or A or C Nylon	
	OR					

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
33.	<u>Fell lining</u> - Contd					
	f. In lieu of the basting of the lining at the shoulders that is specified in Operation 30.c and the hand felling that is specified in 33.e trim the front lining and the back lining to allow for the thickness of the shoulder pad and stitch on the inside.	301	SSa-1	10-14	A	A
	g. Fell the bottom edge of the lining to the coat.	Hand or		6-8	A or C Silk or A or C Nylon	
		306		6-8	A	A Polyester
	h. Fell the lower back edge of the front facings to the bottom corners of the hem of the lining at the joining of the lining to the front facing.	Hand		6-8	A or C Silk or A or C Nylon	
	NOTE: The bottom edge of the front facing shall not extend below the bottom edge of the finished coat.					

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
34.	<p><u>Mark and make buttonholes.</u></p> <p>a. Mark the position of the top and the bottom buttonholes on the right front in accordance with the pattern marks. Mark the position of the third buttonhole equidistant between the marks for the top and the bottom buttonholes.</p> <p>b. Make three buttonholes in the right front at the locations marked for the buttonholes.</p> <p>NOTE: The buttonholes shall be 7/8 inch long. The buttonholes shall be cut-first, eyelet-end, square-bar buttonholes. The buttonholes shall be worked over gimp, with the gimp pulled through the underside of the buttonholes. The eyelet of each buttonhole shall be 1/2 to 5/8 inch from the edge of the front. The bartacking and the button-hole making shall be separate operations.</p> <p>c. Bartack the end of each buttonhole.</p>	Button-hole		70 stitches per button-hole not including bartack	B Silk or B Nylon or F Nylon	B or C Silk or B Nylon or F Nylon
		Bartack or Hand		21 stitches per bartack 10-12 stitches per bartack	A Silk or O Nylon or A Nylon	

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
34.	<u>Mark and make buttonholes.</u> - Contd NOTE: If the bartacking of the buttonholes is done by hand, the bartack shall be not more than 3/16 inch long.					
35.	<u>Clean coat.</u> a. Remove the basting threads. b. Trim the ends of all stitching. Remove loose thread from the coat. c. Remove all spots and stains. d. Remove the shade tickets.					
36.	<u>Finish press.</u> a. Press the edges and the bottom (edge pressing machine). NOTE: The coat shall be placed on a hanger after the first pressing operation in the final press until after the last pressing operation in the final press. b. Press the fronts (front machine). NOTE: The front edge shall effect a straight line from the top button to within 3 inches of the bottom of the coat. c. Press the backarm and the forearm seams of the sleeves (sleeve seam machine).					

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
36.	<p><u>Finish press</u> - Contd</p> <p>NOTE: The sleeves shall be roll pressed.</p> <p>d. Press the back (back machine).</p> <p>e. Press the collar and the lapels at the breakline, with a collar pressing machine, pressing the crease line 2 inches below the collar and the lapel gorge seam.</p> <p>NOTE: The lapels shall be roll pressed.</p> <p>f. Press the armholes and the shoulders (armhole machine).</p> <p>g. Crease the lower half of each armhole solid on the inside edge of the armhole.</p> <p>h. Block the armholes.</p> <p>i. Press the lining smooth.</p> <p>j. Press the pleats in the center back and in the fronts of the lining.</p> <p>k. As an option to Operations 8.d and 36.j, press each bust dart and each shoulder dart in the lining, forming a pleat, with the front end of the dart (pleat) tapering to nothing.</p> <p>l. Remove gloss, wrinkles, creases, and all pressing impressions from the coat.</p>					

TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
36.	<u>Finish press.</u> - Contd m. Brush the coat. NOTE: The collar and the lapel shall conform to the individual finished shapers, respectively. Position the collar shaper over the collar from the point of the shoulder aligning with gorge seam of coat and matching collar point to shaper. Position the lapel shaper over the lapel aligning with gorge seam and breakline of coat, matching collar point to shaper.					
37.	<u>Tack shoulder loops.</u> Center the neck end of each shoulder loop on the shoulder seam. Fell the shoulder loop to the undercollar only with a hand blindstitching the total width of the shoulder loop end.	Hand		6-8	A or C Silk or A or C Nylon	
38.	<u>Mark and sew on buttons.</u> a. Mark the location of the three buttons on the left front to correspond with the three buttonholes on the right front.					

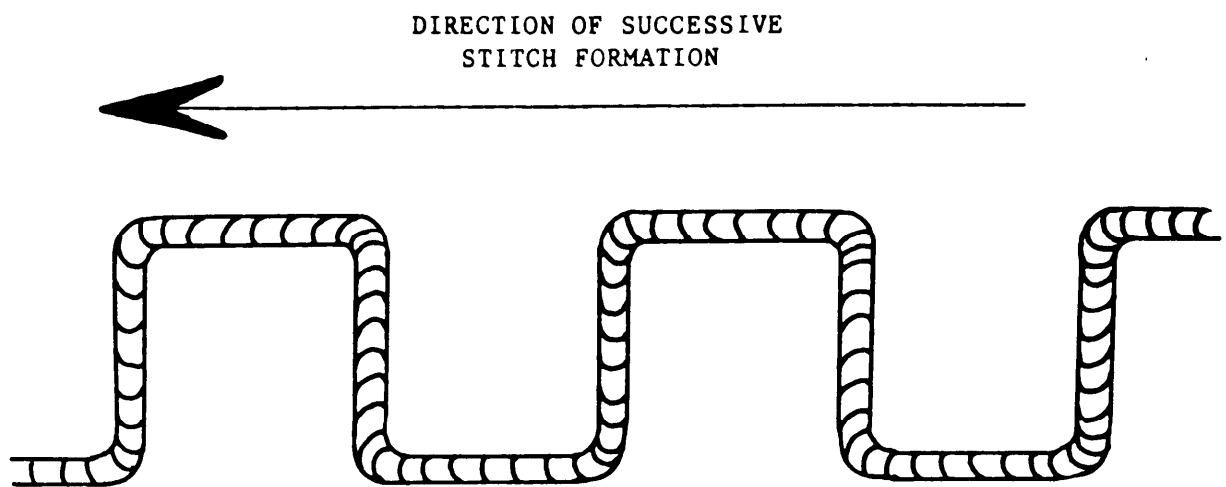
TABLE III. Manufacturing operations. - Continued

No.	Description of Operation	Stitch Type	Seam and Stitching Type	Stitches Per Inch	Thread	
					Top	Lower
38.	<u>Mark and sew on buttons.</u> - Contd					
	b. Sew three 30-line buttons, 1/2 to 5/8 inch from the front edge, to the left front as indicated by the patterns, with the stitching caught through the front interlining and the front facing.	101 or		20-22 stitches per button	12 or 20	
		301 or		14-16 stitches per button	20	20
		Hand or		4 stitches per button double thread	12 or 16	
		801 (see Fig 1)		12 stitches per button minimum	Nylon No. 4	
	NOTE: If the buttons are sewn by hand, the sewing shall be back-stitched with not less than two stitches and the ends of the stitching shall be hidden.					

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or purchase order, the contractor may use his own or any other facility suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

NOTE: Stitch class 800 shall be formed with one or more needle threads and has a general characteristic that the thread does not interloop with itself or any other thread or threads. The thread is passed completely through the material by means of a double pointed center eye needle and returned by another path. Stitch class 800 simulates hand stitching.



Stitch type 801 shall be formed with one needle thread which is passed completely through the material and returned by another path after the material has been moved forward one stitch length.

FIGURE 1. Stitch type 801.

TABLE IV. Finished measurements (inches).

Sizes	1/2 Bust <u>1/</u>	Back Length <u>2/</u>	Sleeve Inseam <u>3/</u>
<u>Short</u>			
6	17-1/2	25	15-1/2
7	18	25-1/8	15-1/2
8	18-1/2	25-1/8	15-1/2
9	18-3/4	25-1/4	15-1/2
10	19	25-1/4	15-1/2
11	19-1/4	25-3/8	15-1/2
12	19-1/2	25-3/8	15-1/2
13	19-7/8	25-1/2	15-1/2
14	20-1/4	25-1/2	15-1/2
15	20-5/8	25-5/8	15-1/2
16	21	25-5/8	15-1/2
<u>Regular</u>			
6	17-1/2	26	16-1/2
7	18	26-1/8	16-1/2
8	18-1/2	26-1/8	16-1/2
9	18-3/4	26-1/4	16-1/2
10	19	26-1/4	16-1/2
11	19-1/4	26-3/8	16-1/2
12	19-1/2	26-3/8	16-1/2
13	19-7/8	26-1/2	16-1/2
14	20-1/4	26-1/2	16-1/2
15	20-5/8	26-5/8	16-1/2
16	21	26-5/8	16-1/2
18	22	26-3/4	16-1/2
20	23	26-7/8	16-1/2
<u>Long</u>			
6	17-1/2	27	17-1/2
8	18-1/2	27-1/8	17-1/2
10	19	27-1/4	17-1/2
12	19-1/2	27-3/8	17-1/2
14	20-1/4	27-1/2	17-1/2
16	21	27-5/8	17-1/2
18	22	27-3/4	17-1/2
Tolerance	<u>+1/2</u>	<u>+3/8</u>	<u>+3/8</u>

TABLE IV. Finished measurements (inches). - Continued

- 1/ Measure the 1/2 bust at the underarm, with the coat buttoned, across the front from armhole to armhole.
- 2/ Measure the back length from the center back, bottom of the under collar to the finished hem.
- 3/ Measure the sleeve inseam, along the sleeve inseam, from the armhole seam to the bottom of the sleeve.

4.1.1 Responsibility for compliance. All items shall meet all requirements of sections 3 and 5. The inspection set forth in this specification shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the contractor of the responsibility of assuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract. Sampling in quality conformance does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to acceptance of defective material.

4.1.2 Certificate of compliance. Where certificates of compliance are submitted, the Government reserves the right to check test such items to determine the validity of the certification.

4.2 Classification of inspections. The inspection requirements specified herein are classified as follows:

- a. First article inspection (see 4.4).
- b. Quality conformance inspection (see 4.5).

4.3 Inspection conditions. Unless otherwise specified, all inspections shall be performed in accordance with the test conditions specified in FED-STD-191 or MIL-STD-1608, as applicable.

4.4 First article inspections. When a first article is required (see 6.2), it shall be examined for the defects specified in 4.5.3. The presence of any defect shall be cause for rejection of the first article.

4.5 Quality conformance inspection. Unless otherwise specified, sampling for inspection shall be in accordance with MIL-STD-1608.

4.5.1 Components and material inspection. In accordance with 4.1, components and materials shall be inspected in accordance with all the requirements of referenced documents unless otherwise excluded, amended, modified, or qualified in this document or applicable purchase document.

4.5.1.1 Component testing. In addition to any testing required by 4.5.1, components shall be tested as shown in table V for the characteristics noted. The methods of testing specified in FED-STD-191 and as listed in table V shall be followed. All test reports shall contain the individual values used in expressing the final results. The number of sample units to be tested shall be determined as follows:

<u>Lot size</u>	<u>Sample size</u>
800 or less	2
801 up to and including 22,000	3
22,001 and over	5

The lot shall be unacceptable if one or more sample units fail to meet any test requirement specified. The lot size units and the sample units shall be as follows:

<u>Component</u>	<u>Lot size unit</u>	<u>Sample Unit</u>
Braid	Yard	5 yards
Gimp	Bobbins when used (see NOTE)	Sufficient number of bobbins to total a minimum of 360 yards.

NOTE: When threads are purchased in the form of cones or spools and on bobbins, gimp from each shall be tested.

4.5.2 In-process inspection. Inspection shall be made at any point or during any phase of manufacturing to determine whether operations or assemblies are accomplished as specified and to verify that the working patterns conform to the Government patterns in all respects. The Government shall reserve the right to exclude from consideration for acceptance any material or service for which in-process inspection has indicated nonconformance.

4.5.2.1 Examination of coat assembly. The coat shall be examined on its equivalent size model form to insure that the coat has been properly assembled to conform to the following:

- a. The sleeves shall hang and balance evenly.
- b. The front and the back of the sleeves shall have a roll effect.
- c. The collar shall set snugly around the neck.
- d. The collar edges shall not curl.
- e. The fronts shall not overlap diagonally nor spread apart.
- f. Breaks, creases, or twists shall not be visible at the side or the shoulder.

Whenever nonconformance is noted, correction shall be made to the items affected, the lot in progress, and to the assembly of the coat. Parts which cannot be corrected shall be removed from production.

TABLE V. Component tests.

Component	Characterisite	Requirement paragraph	Test method
Braid	Material identification	3.3.8	1200 or 1500 <u>1/</u>
	Width	3.3.8	5020
	Breaking strength (warp direction)	3.3.8	<u>2/</u>
	Colorfastness to:		
	Dry cleaning	3.3.8	5622
	Crocking	3.3.8	5651
Gimp	Material identification	3.3.14	1100 or 1200 <u>1/</u>
	Finish	3.3.14	Visual
	Weight	3.3.14	4010
	Color	3.3.14	Visual
	Colorfastness to:		
	Dry cleaning	3.3.14	5622

1/ A certificate of compliance is acceptable for this requirement.

2/ Test method shall be 5100 of FED-STD-191 except that the breaking strength shall be determined in the full width of the braid and the jaw dimensions shall be greater than the width of the braid.

4.5.3 End item inspection

4.5.3.1 Individual examination. As a final step in the contractor's production control plan and before formation of a lot, each coat shall be buttoned on a model form and examined for those defects identified by an asterisk (*) and listed as selected defects in MIL-STD-1608. Any coat containing a selected defect shall not be included in an end item lot.

4.5.3.2 Point count inspection. After the coats have been subjected to the individual examination, sampling and inspection provisions for end item examination, dimensional examination, and packaging inspection shall be performed in accordance with MIL-STD-1608. Packaging inspection of hanger packs shall be in accordance with MIL-C-44192. The occurrence of defects during these examinations shall not exceed the applicable point value or defect limit specified.

4.5.3.3 Palletization examination. Examination shall be made to determine that the palletization complies with the section 5 requirements. Defects shall be scored in accordance with the list below. The sample unit shall be one palletized unit load fully packaged. The lot size shall be the number of palletized unit loads in the inspection lot. The inspection level shall be S-1 and the acceptable quality level, expressed in terms of defects per hundred units, shall be 6.5 as specified in MIL-STD-105.

<u>Examine</u>	<u>Defects</u>
Finished dimensions	Length, width, or height exceeds specified maximum requirements.
Palletization	Pallet pattern not as specified. Interlocking of loads not as specified. Load not bonded with required straps or film as specified.
Weight	Exceeds maximum load limits.
Marking	Omitted; incorrect; illegible; of improper size, location, sequence, or method of application.

5. PACKAGING

5.1 Preservation. Preservation shall be level A, C, or Commercial, as specified (see 6.2).

5.1.1 Level A. Prior to packing, the shipping container shall be provided with an interior case liner made from polyethylene film having a minimum thickness of 0.003 inches. The open top of the liner shall be of sufficient length to completely cover the stack of coats when closed. The liner shall be closed by folding the top down onto the stack and securing with pressure sensitive tape or by means of a mechanical tie prior to closure onto the container. Each coat shall be buttoned and shall then be laid back down with the sleeves extending neatly across the front. The bottom of the coat shall be folded up even with the top of the collar. The folded coat shall be approximately 23 inches by 15 inches.

5.1.2 Level C. Each coat shall be preserved in accordance with MIL-STD-2073-1.

5.1.3 Commercial. Coats shall be preserved in accordance with ASTM D 3951.

5.1.4 Hanger packs. Coats shall be preserved as specified in MIL-C-44192.

5.2 Packing. Packing shall be level A, B, C, or Commercial as specified (see 6.2).

5.2.1 Level A. Fifteen coats of one size, preserved as specified in 5.1, shall be packed flat in a shipping container conforming to class V2s, style RSC-L of PPP-B-636. The shipping container shall be fitted with a liner that is constructed of V15C fiberboard. The approximate inside dimensions of the shipping container shall be 23-1/1 inches long, 15-1/2 inches wide, and 15 inches deep. The closure of the shipping container shall be in accordance with method III of the appendix of the shipping container specification. Towards the end of the contract or order, or if the quantity of coats of the same size is less than the quantity of coats required per shipping container, mixed sizes (see 5.3.1) may be packed within the same shipping container.

5.2.2 Level B. Fifteen coats of one size only, preserved as specified in 5.1, shall be packed flat in a shipping container conforming to type CF or SF, class domestic, grade 175, variety SW, style RSC-L of PPP-B-636. The shipping container shall be fitted with a liner that conforms to type CF, variety SW, grade 200 of PPP-B-636. The approximate inside dimensions of the shipping container shall be 23-1/2 inches long, 15-1/2 inches wide and 15 inches deep. The closure of the box shall be in accordance with method II of the appendix of the shipping container specification. Towards the end of the contract or order, or if the quantity of coats of the same size is less than the quantity of coats required per shipping container, mixed sizes (see 5.3.1) may be packed within the same shipping container.

5.2.3 Level C. Fifteen coats of one size, preserved as specified in 5.1, shall be packed in accordance with MIL-STD-2073-1.

5.2.4 Commercial. Fifteen coats of one size, preserved as specified in 5.1, shall be packed in accordance with ASTM D 3951.

5.2.5 Hanger pack. Twelve coats of one size, preserved as specified in 5.1, shall be packed in a type I container using a style A or B hanger bar, in accordance with MIL-C-44192.

5.3 Palletization. When specified (see 6.2), coats packed as specified in 5.2, shall be palletized on a 4-way, type I, style 1, 1A, or 1B, size A, class 1 pallet fabricated in accordance with MIL-P-15011 or on a 4-way, type IV, V, or VIII, class 1, size 2, grade A pallet fabricated in accordance with NN-P-71. Each prepared load shall be in accordance with load type I or Ia and bonded with the applicable strap bonding or film bonding means specified in MIL-STD-147. The pallet pattern shall be in accordance with the appendix of MIL-STD-147. Interlocking of loads shall be effected by reversing the pattern of each course. If the container is of a size which does not conform to any of the patterns specified in MIL-STD-147, the pallet pattern used shall be approved by the contracting officer.

5.3.1 Hanger pack. When specified (see 6.2), coats packed as specified in 5.2, shall be palletized in accordance with the appendix of MIL-C-44192 using pallet load pattern number 95.

5.4 Marking. In addition to any special markings required by the contract or purchase order, the bagged unit packs, the shipping containers or hanger packs as specified (see 6.2), and the palletized unit loads shall be marked in accordance with MIL-STD-129, ASTM D 3951, or the appendix of MIL-C-44192, as applicable.

5.4.1 Labels, mixed sizes. Each shipping container or hanger pack that is packed with mixed sizes shall have securely attached to the end and side, directly under the printing, stenciling or arrows, a white paper label 5 by 4 inches with the words "MIXED NSN'S" plainly stamped or printed thereon and under these words shall be legibly stamped or printed the correct quantity and NSN's contained therein.

6. NOTES

6.1 Intended use. The pants suit coat is intended to be worn by female personnel of the Department of the Air Force.

6.2 Ordering data

6.2.1 Acquisition requirements. Acquisition documents should specify the following:

- a. Title, number, and date of this specification.
- b. Class, size and length required (see 1.2).
- c. When a first article is required (see 3.2).
- d. Selection of applicable levels of preservation and packing (see 5.1 and 5.2).
- e. When palletization is required (see 5.3).
- f. When bar code markings are required (see 5.4).

6.3 Samples. For access to samples of the end item and shade samples, address the contracting activity issuing the invitation for bids.

6.4 First article. When a first article inspection is required, the item should be a first article sample, inspected and approved under the appropriate provisions of FAR 52.209-4. The first article should consist of one coat. The contracting officer should include specific instructions in acquisition documents regarding arrangements for examinations, approval of first article test results and disposition of first article. Invitations for bids should provide that the Government reserves the right to waive the requirement for samples for first article inspection to those bidders offering a product which has been previously acquired or tested by the Government, and that bidders offering such products, who wish to rely on such production or test, must furnish evidence with the bid that prior Government approval is presently appropriate for the pending contract.

6.5 Recycled material. It is encouraged that recycled material be used when practical as long as it meets the requirements of this document (see 3.3).

6.6 Subject term (key word) listing.

Coat, pant suit
Coat, woman's

6.7 Changes from previous issue. Asterisks (*) are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.

Custodian:

Air Force - 11

Preparing activity:

Air Force - 11

Review activities:

Air Force - 82, 99

DLA - CT

User activity:

Air Force - 45

Project No. 8410-F670

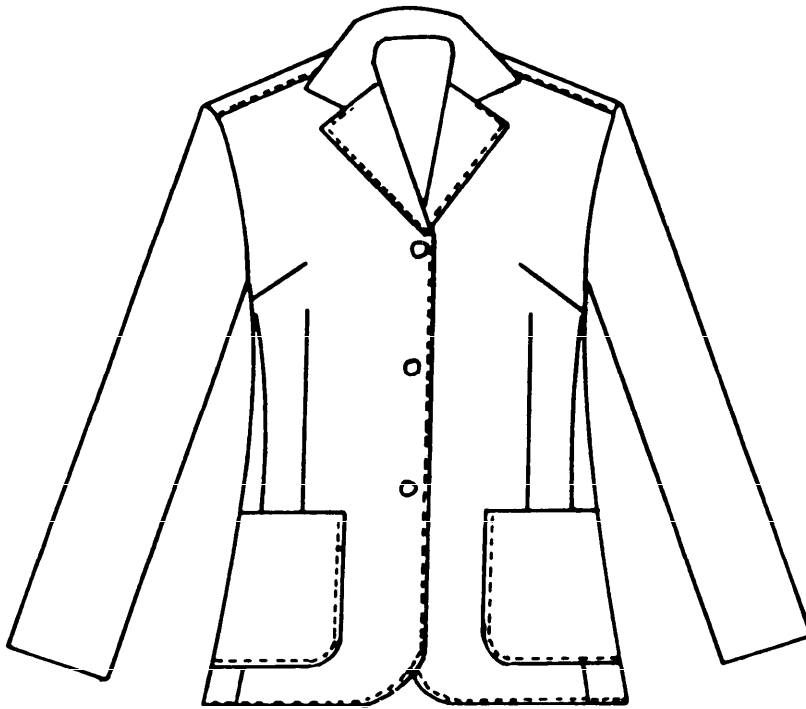


FIGURE 2. Coat, woman's pant suit (front view).

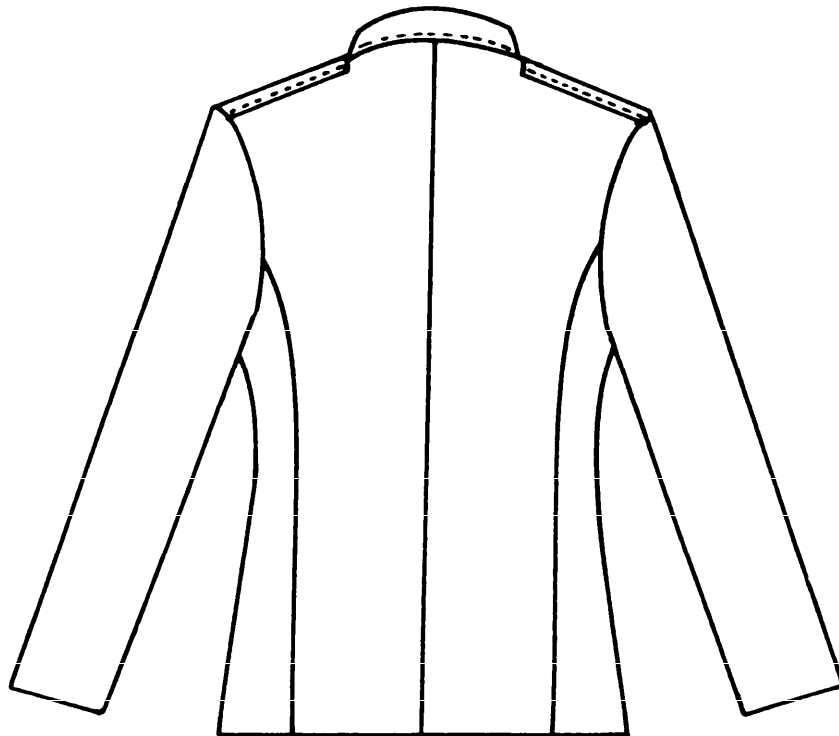


FIGURE 3. Coat, woman's pant suit (back view).

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